

Date: Monday, 07/07/2008 4:23:39 PM
 User: Julie Lecocq

Process Sheet

split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE ASSEMBLY (INTERIOR)
Job Number	: 40349-2	Part Number	: D3779043
Estimate Number	: 13332	Drawing Number	: D3779 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 07/07/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SMALL / MED FAB	Due Date	: 28/07/2008
Previous Run	: 39362	Qty:	10 Um: Each
Written By	:		
Checked & Approved By	: <u>JUD 08-7-07</u>		
Comment	: Est Rev:A 08-05-20 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.4583 sf(s)/Unit Total : 4.5833 sf(s)
 6061-T6 .125 Sheet
 batch: 106634 HB 8-7-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3779
 Dwg Rev: A
 Prog Rev: 1

HB 8-7-15

(12)

2-Deburr if necessary HB 8-7-15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

808/14/15 (12)

(P10) →

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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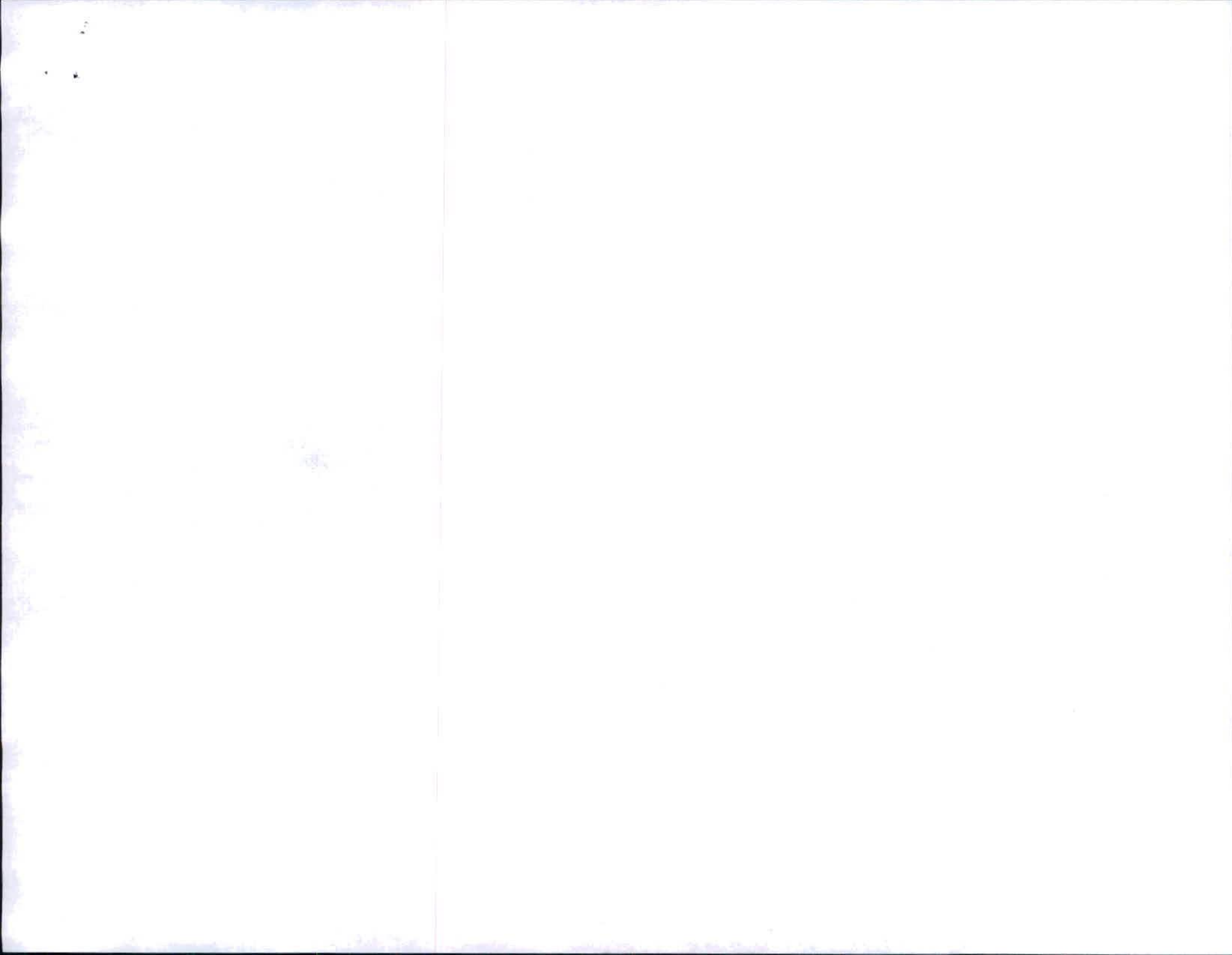
Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

Dart Aerospace Ltd

W/O: 40349		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/07/21	1	Small fab countersink and deburr	FF	08/07/23			
	2	QC 5	S	08/07/23	(12)		
	3	Chemical conversion coat		08/07/24	(12)		
	4	QC 3		08/07/24	(12)		

Part No: D3779-013 PAR #: _____ Fault Category: Prod. Eng. Coordination NCR: Yes No DQA: _____ Date: _____
QA: N/C Closed: _____ Date: _____

NCR: 40349-2		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/15	40	During A/C inspection it was found that the hole spacing of 6.960" is actually 7.000"		update program on water jet to correct Drill and perforate	08/07/15			
		RC Program on water jet was not updated as per the Draw. D3779-5, operator took Program from Prelm.		Scrap and Destroy and replace Qty (12) BA M100634	08/07/15			



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY (INTERIOR)

Job Number: 40349

Part Number: D3779043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

D32031

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Handle

batch: 30158A 3x

B40353 9x

12/25 (12)

7.0

MS20426AD10 18

Rivet Countersunk



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet Countersunk

batch: 1107936

or (MS20426AD10-10)

CU

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

12/21

1- counter sink holes as per dwg D3779-

2- deburr

3- rivet D3203-1 handle to D3779-5 plate as per dwg D3779 per QSI003

FF 08/10/06

(1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/06 (x)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

12/26 (1)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



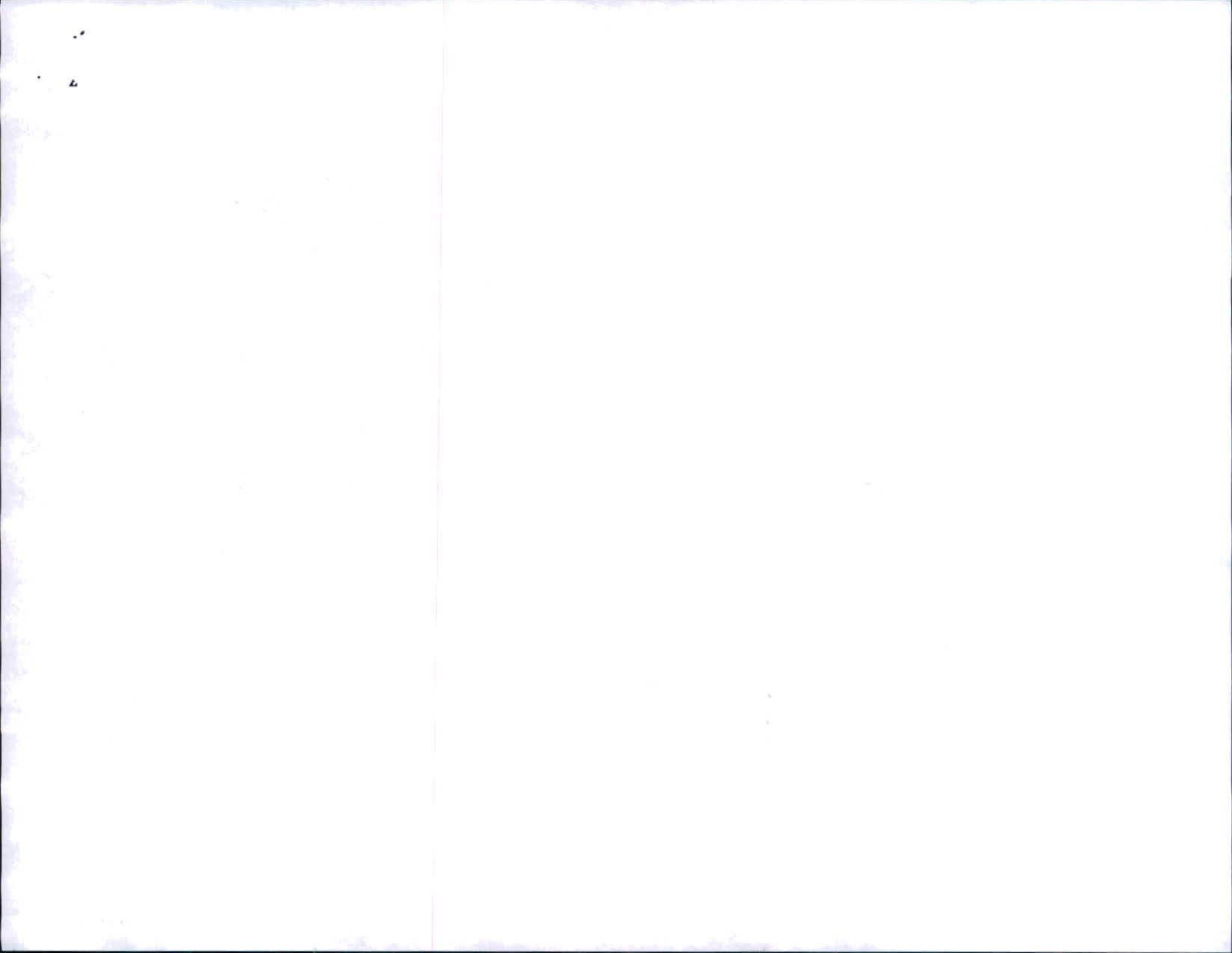
Comment: FINAL INSPECTION/W/O RELEASE

08/10/06

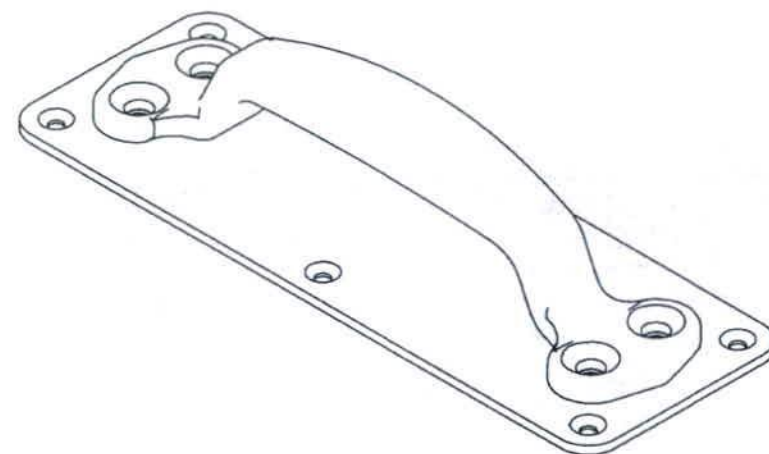
Job Completion



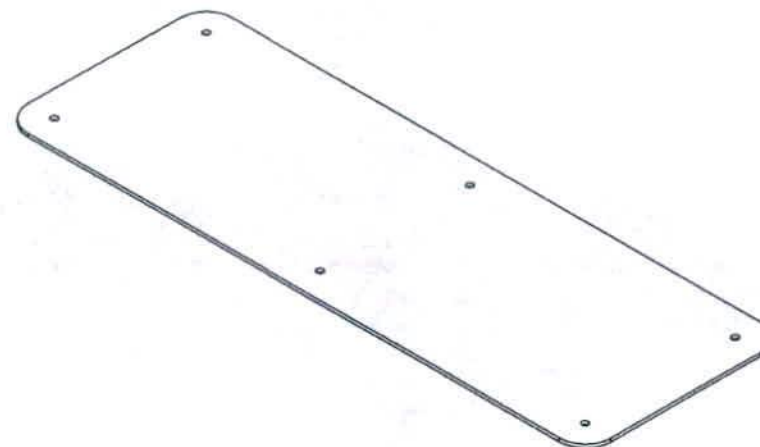
12/26/06



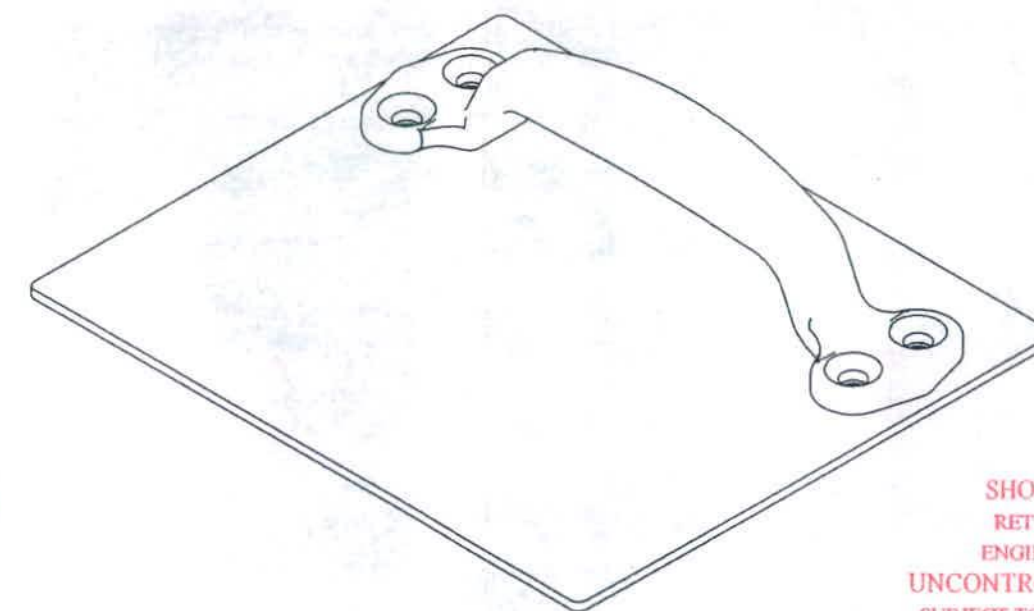
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-8	RIVET, CSK



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



D3779-3 DOUBLER PLATE

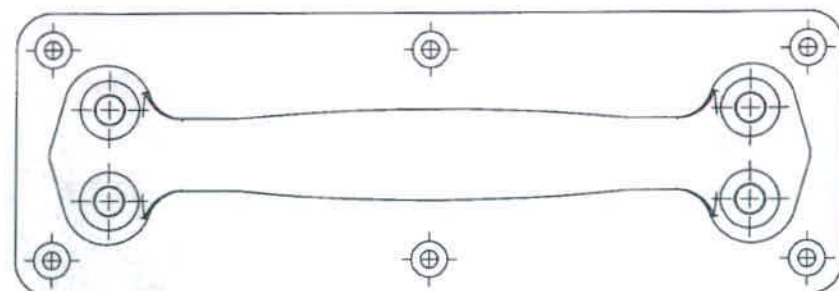


D3779-043 HANDLE ASSEMBLY
(INTERIOR)

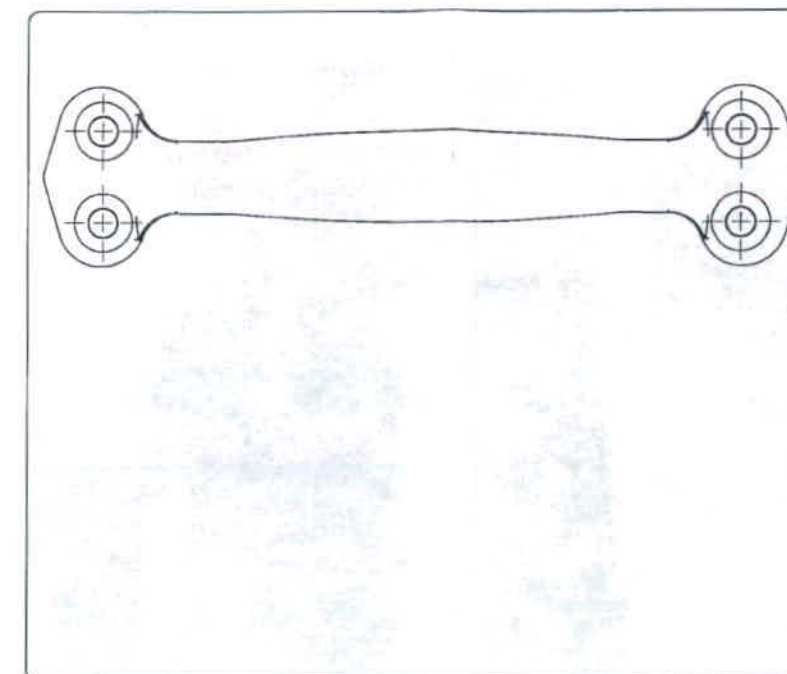
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WITHOUT NOTICE
WORK ORDER NO. 40348-2

RELEASED
08-06-26 MP

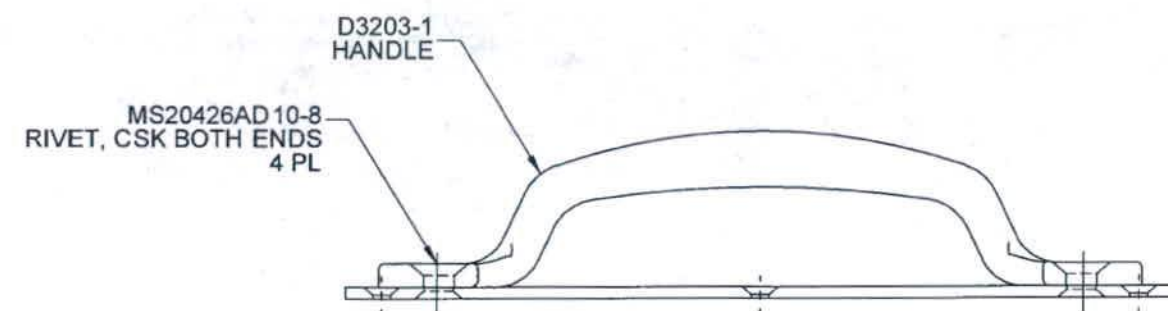
A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
DATE	08.04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



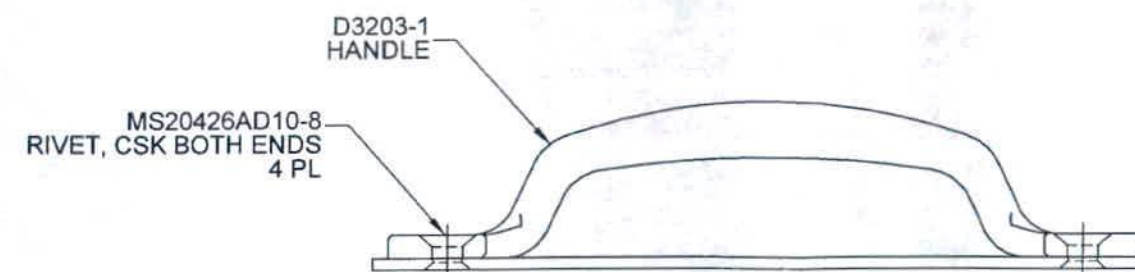
D3779-1
PLATE



D3779-5
PLATE



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



D3779-043 HANDLE ASSEMBLY
(INTERIOR)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30348-2

RELEASED
08-06-26 1/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 2 OF 4
APPROVED		TITLE	HANDLE ASSEMBLY, SCALE
DE APPR.		CABIN SLIDING DOOR	NTS
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